

5/45

133

DART AEROSPACE LTD	Work Order:	24501
Description: Hinge Bracket	Part Number:	D2857-1
Drawing: D2857 Rev. A1	Qty:	24

RF 03.09.05

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	(X)	05/10/12	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)			
3	HAAS	Machine per folio D2857-1	M8	05/10/25	24
4	QC	Inspect Level 2	M8	05/10/25	24
5	METAL	Tumble N/A Deburr any rough edges after tumbling	M8	05/10/25	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	SAD	05/11/19	24
7	QC	Inspect Level 7	MM	05/11/24	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	MM	05/11/24	24
9	QC	Inspect Level 3	CL	05/11/25	24
10	STORES	Identify and stock	LOC	05/11/25	24
11	EXPEDITING	Close W/O Cost / Part: 5.45 05/11/28	(Z)	05/11/28	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

EJ JUN 26 2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 05/11/28

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD		Work Order:	24501
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857	Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

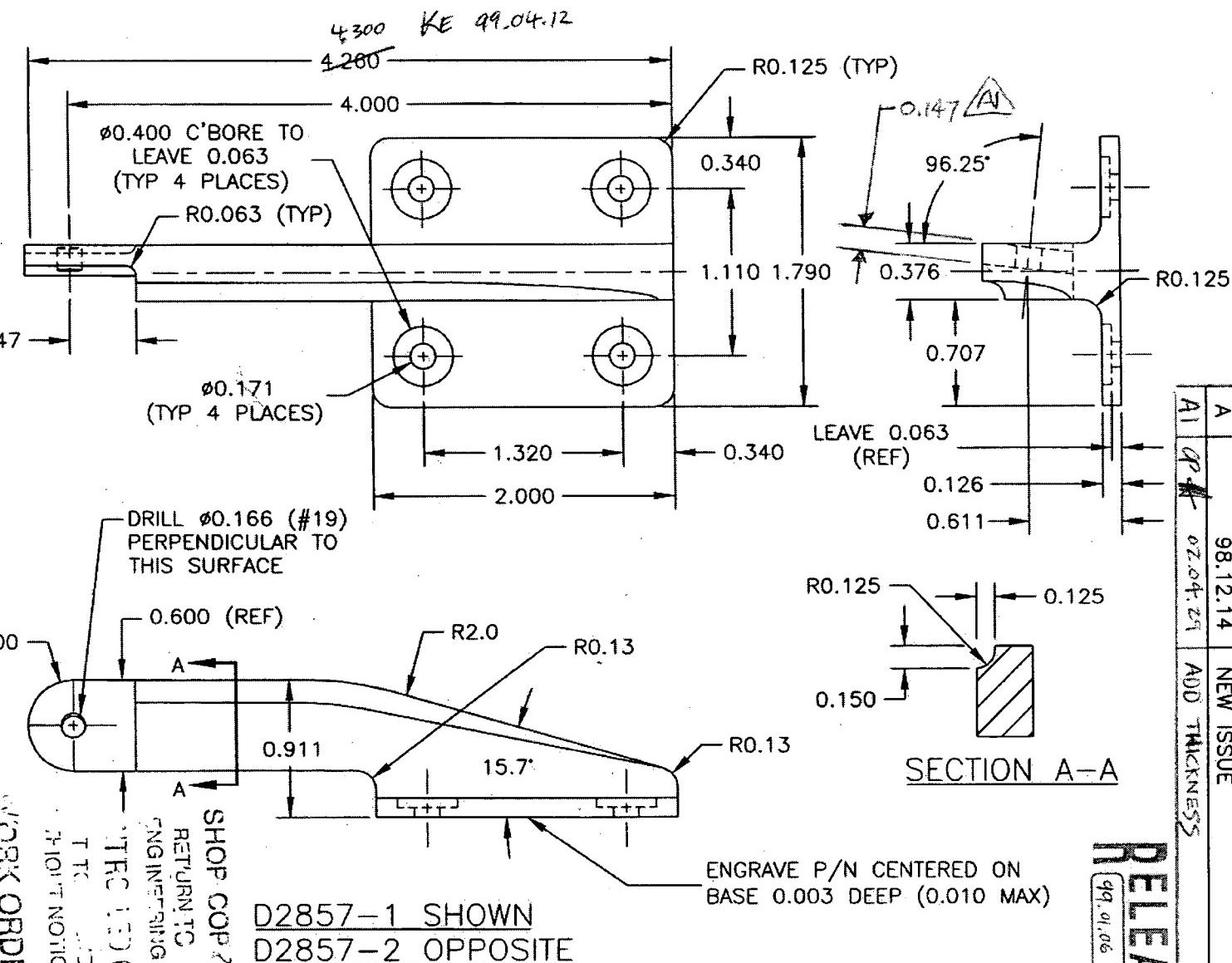
First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.303	✓			
0.340	+/-0.010	.337	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.789	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	1.997	✓			
Ø0.171	+0.005/-0.000	.173	✓			
0.147	+/-0.010	.153	✓			
0.376	+/-0.010	.373	✓			
0.126	+/-0.010	.127	✓			
0.063	+/-0.010	.063	✓			
0.166	+0.005/-0.000	.167	✓			
0.911	+/-0.010	.910	✓			
0.600	+/-0.010	.601	✓			
0.125	+/-0.010	.125	✓			
0.150	+/-0.010	.141	✓			

Measured by:	BG	Audited by:	SG	Prototype Approval:	N/A
Date:	05.10.24	Date:	05/10/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	✓

RELEASED
11/04/2017



WORK ORDER
NO. 24501

MATERIALS: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

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RIGHT

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	JG	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	JG	D2857
DATE	DATE	REV. A
98.12.14	98.12.14	NEW ISSUE
A1	02.04.21	ADD THICKNESS
TITLE	SCALE	SHEET 1 OF 1
HINGE BRACKET	1:1	

RELEASED
99.01.06 KE

Job Costing Report

Dart Aerospace Ltd.
HawkesburyOct 11, 2005
07:41 am

Work Order No : 0024501
 Project Name : D2857-1
 Project For : WK545
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2857-1
 Description : Hinge Bracket
 Manufactured : Yes
 Amount Req'd : 24
 Amount Done : 0
 Start Date : 10-08-05
 Est Finish Date : 11-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00		
=====		=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:21 pm

Work Order No	:	0024501	Department Code:	
Project Name	:	D2857-1	Burden Flags	: NNNNNNNN
Project For	:	WK545	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2857-1	Invoice Number	:
Description	:	Hinge Bracket	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	24	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	10-08-05	Est Margin	: 0.000%
Est Finish Date	:	11-15-05	Actual Margin	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	28.50	100.00		
Production Cost	: 0.00	680.25	100.00	0.00	680.25
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	17.00	100.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	680.25	100.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	680.25			
Labour Hrs/Amount Done	: 0.00	0.00			
Profits/(Loss)	: 0.00	(-680.25)			

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HINGE BRACKET		
Job Number	: 24501			Part Number	: D28571		
Estimate Number	: 10345			Drawing Number	: D2857 REV A1		
P.O. Number	:			Project Number	:		
This Issue	: 14/11/2005	S.O. No.	:	Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 30/11/2005 Qty: 24 Um: Each		
Previous Run	:						
Written By	:						
Checked & Approved By	:						
Comment	: Est C 00.06.22 Removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 5.2"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2857-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble 2-Deburr any rough edges after tumbling		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.3		

Date: Monday, 14/11/2005 8:28:28 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 24501

Part Number: D28571

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

